120

QC

Quality Control

120

Memo

QC8- Inspect parts - second check

												A.
										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ON	NFORM	MANCE / UP		QA Closed:	Date:	
Work Order	Part No. Part No. NCR No. DISPOSITION Rework Skid-tube Crosst Machining Small Thermoforming Large Fab Compo Compo Couse Date Step Qty Or Non-conformance Couse Date Description					AGAINST DE	PARTMENT	/PROCESS				
Part No.	Part No. NCR No. Root Cause Date Step Qty Ip/Tooling erator terial up				Scrap Use-as-is		Thern	Machining noforming	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	li	nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process									-	Mark (Market		·

			FAUI	LT CATEGORY			
Landing	Gear	General		_		_	_
	Bending	Bend		Grain		Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	4	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance		Part Moved	
	Heat Treat	Countersink		Mislabeled		Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset			
	Torque Waves in Extrusion	Drawing ,		Out of Calibration			
	Turning Sequence	Finish		Out of Sequence			
	Wave/Twist in Tube	Folio		Outside Dimensions			

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Supplier Training Unapproved

140 *140*

Quality Control

QC3- Inspect Part Finish

Memo

0.00

10

150

Identify as per dwg & Stock Location:

150

Packaging Packaging

Memo

0.00

Insp.

Page 2

NICD.	Voc	1	No
NCR:	Yes	/	No

NCR: Y	⁄es	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPI	DATE		DQA:	Da	ite: _	
		,										QA Closed:	Da	ite:	
Work Orde	er:					DISPOSITION		-		AGAINST	DE	PARTMENT	/PROCESS		
Part N	-					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		i	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root	- 			<u> </u>	Descr	ription of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	Desc.	or Non-conformance	1	nief Eng		ription		Date	Verificatio	n	QC Inspector
oc/Data quip/Tooling Derator Material etup Other rocess upplier raining															
							FAUL	T CATE	GORY						
Landii		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning Si	Crimped it n Strip in Bend Vaves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of 0	on Incomplete ions Incomplete/Unance led	Jnclear 		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw				Folio		1	Dimensions						

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Work Ord <i>May-13-13 1:6</i>		01598		*101	598*							Page 3
Item ID: Revision ID:	D3238-11			Accept	*N900	040	100)*	Setup Si			S1*
Item Name:	Plate								3	top	*N:	S2*
Start Date:	5/13/13	Start Qty: 10.00	*10*		Cust Item I	D:						
Required Date	e: 5/31/13	Req'd Qty: 10.00	*10*		Customer:							
Reference:												, i
Approvals:	Process F	Plan:	Date:	Tooling:	· Da	ate:	_ 	ì		tart	*N!	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			S	top	*NI	R2*
Sequence ID/ Work Center	ID	Operation Description	<u></u>	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
160		QC21- Final Inspection -	Work Order Release	0.00								
160		Memo		0.00				_MU	<u> </u>	<u>-0</u> (6-05	

Quality Control

N 13-06-4

			1								DQA:	Date	·
NCR: Y	es	/ No	Ć.			WORK ORDER NON-	COI	VFOR	MANCE / UPE	DATE	QA Closed:	Date	
· · · · · · · · · · · · · · · · · · ·	-					DISPOSITION				ACAINST D			-
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	
Part N	o.					Rework Scrap		l .	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	o			······································	<u></u>	Use-as-is Work Order Update		1	noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	iption of work order update	Ti	nitial	Acti	ion	Sign &	ı	
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
oc/Data													
quip/Tooling							ł						
perator	_					•							
/laterial	╝										1		
etup													
Other	\Box												
rocess	\Box												
upplier											1		
raining													,
napproved													
							AUL	T CATE	GORY				
Landin	g G	ear			_	General		1			_	_	- -
	_	Bending				Bend	_	Grain			Ovalized	_	Pressure/Forced
	—;	Centre No	t Concer	ntric to	o/s	BOM/Route	_	Hardwa		_	Over/Under	 	Temperature/Cure
1		Cracks /				Broken/Damaged	-	1 '	on Incomplete		Part Incorred	-	Weld
1	اٰ	Crushed/0	Crimped			Burrs		1	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
1		Cuffs				Contamination		Mainte	nance	_	Part Moved		
		Heat Trea	t			Countersink	L	Mislabe	led		Positioned W		¬
1	\neg	Inspection	-	Tube	_	Cut Too Short	\perp	Misread	I	<u></u>	Power Loss/	Surge	Other
		Ripples in	Bend		L	Drill Holes	L	Offset					
		Torque W	aves in E	xtrusio	n L	Drawing	L	Out of (Calibration				
Ī		Turning Se	equence			Finish		Out of 9	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

Picklist Print

May-13-13 1:09:38 PM

Work Order ID:

101598

Parent Item Name:

Parent Item:

Comments:

D3238-11

Plate

IPP Rev:A New Issue 06-10-20 EC

Now on Waterjet 07-01-26 JLM IPP Rev:B

Qty on Qty per Kit Total Unit of Date Status Replacement Last Qty Component Item ID/ Mfg/ Bin Primary Route Measure Hand Issued Issued Location Item Name Seq ID Qty Item ID Purch Item Location 1126316 0,25 sf 0.012 100 0.0000 M5052H32S:020 No Purchased TM13-6-3 5052-1132 .020 Sheet

6061-76 0.020"

119743

119743

Start Date: 5/13/13

Start Qty: 10.00

Page 1

Required Date: 5/31/13

Required Qty: 10.00

											DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UPDATE					
								•			QA Closed:	Da	ate:	
Work Ord	or.					DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS		
Work Ord	C1.		· · · · · ·			Rework	7		Skid-tube Crosst	ube	1	Water Jet		Engineering
Part I	No.					Scrap	1	1	Machining Small		Pro	d. Eng. Coor.	П	Quality
			-		<u> </u>	Use-as-is]	Thern	noforming Finisl	ning	Rec/Sto	re/Packaging		Other
NCR I	No.	<u></u>				Work Order Update			Large Fab Compo	site		Supplier	Ш	
Root			T -		Descr	ription of work order update	Т	Initial	Action		Sign &	1	Т	
Cause		Date	Step	Qty		or Non-conformance		nief Eng	Description		Date	Verification	n	QC Inspector
Doc/Data			<u> </u>				1			-	<u></u>		一	•
Equip/Tooling							1					, ,		
Operator													l	
Material					}								l	
Setup			ļ										ł	
Other	<u></u>				1 : 4								į	
Process			1										ļ	
Supplier	<u>L</u>													
Training	<u></u>													
Unapproved	<u> </u>		<u> </u>	<u> </u>	<u> </u>						ļ	<u> </u>		
							AUI	LT CATE	GORY					
Landi	ng (7			_	General		٦.		_	7			
	<u> </u>	Bending				Bend	<u> </u>	Grain			Ovalized		-	Pressure/Forced
	<u> </u>	Centre No	ot Concei	ntric to	O/S	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under		-	Temperature/Cure
	<u> </u>	Cracks			<u> </u>	Broken/Damaged	_	⊣ '	on Incomplete		Part Incorre		\vdash	Weld
	<u></u>	Crushed/	Crimped		-	Burrs	\vdash	-{	ions Incomplete/Unclear		Part Lost/M	issing		Wrong Stock Pulled
1	1	Cuffs			i	Contamination	1	Mainte	nance		Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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DART AEROSPACE LTD	Work Order:	101598
Description: Plate	Part Number:	D3238-11
Inspection Dwg: D3238 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing	Toloronoo	Actual	A	Bojost	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
2.00	+/-0.030	2.001"	_		V	JLmo1
0.72	+/-0.030	0.729	_		V	
0.36	+/-0.030	0.369"	-		V	
0.34	+/-0.030	0.334"	-		V	
1.328	+/-0.010	1.326"	_		V	
Ø0.203	+0.005/-0.001	0.203	-		V	
						·
					•	
		,				
-						
				·		

Measured by: Jm	Audited by:	0.60	Prototype Approval:	N/A
Date: 13-6-3	Date:	1563	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	07.01.17	New Issue	KJ/JLM 1.A	
В	07.02.23	Dwg Rev. updated	KJ/JLM	臣



DESIGN		CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECI	(ED	APPROVED	DRAWING NO.	REV. C
_	_		D3238	SHEET 1 OF 3
DATE			TITLE	SCALE
07.0	07.02.19		PLATE	1:1
Α		03.11.25	NEW ISSUE	
В		07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
С		07.02.19	ADD 5052-H32 OPTION	

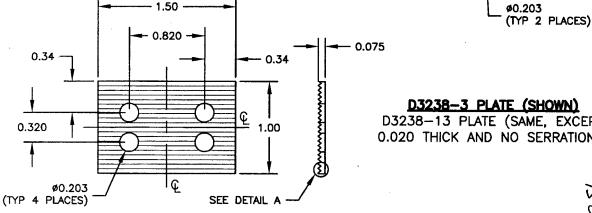
0.34

0.73

2.00

RELEASED 07.02.20

1.328 0.075 -D3238-1 PLATE (SHOWN) 0.36 D3238-11 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS) Œ SEE DETAIL A



D3238-3 PLATE (SHOWN)

D3238-13 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

NOTES:

1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:

ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S)

-11/-13/-15/-31/-33/-35 PLATE:

ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020) OR

ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.020)

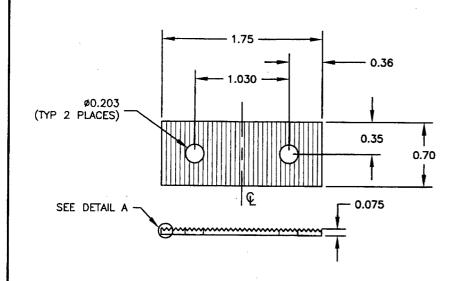
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- PARTS ARE SYMMETRIC ABOUT C

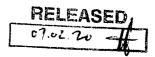
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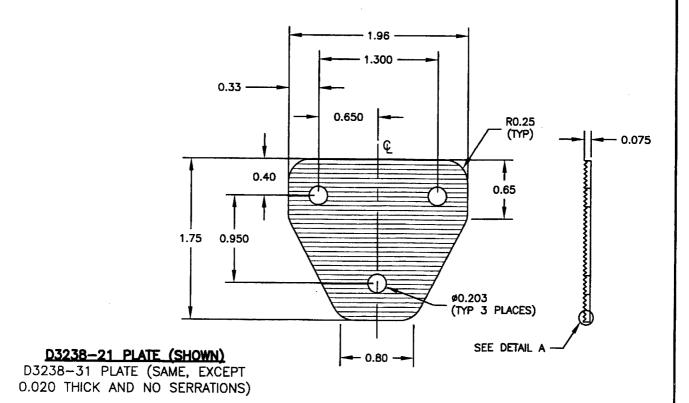


DESIGN	P CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED //	DRAWING NO.	REV. C
LLE	一世	D3238	SHEET 2 OF 3
DATE		TITLE	SCALE
07.02.19)	PLATE	1:1





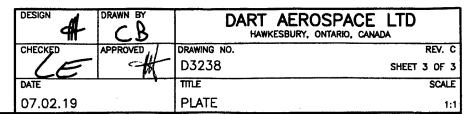
D3238-5 PLATE (SHOWN) D3238-15 PLATE (SAME, EXCEPT 0.020 THICK AND NO SERRATIONS)

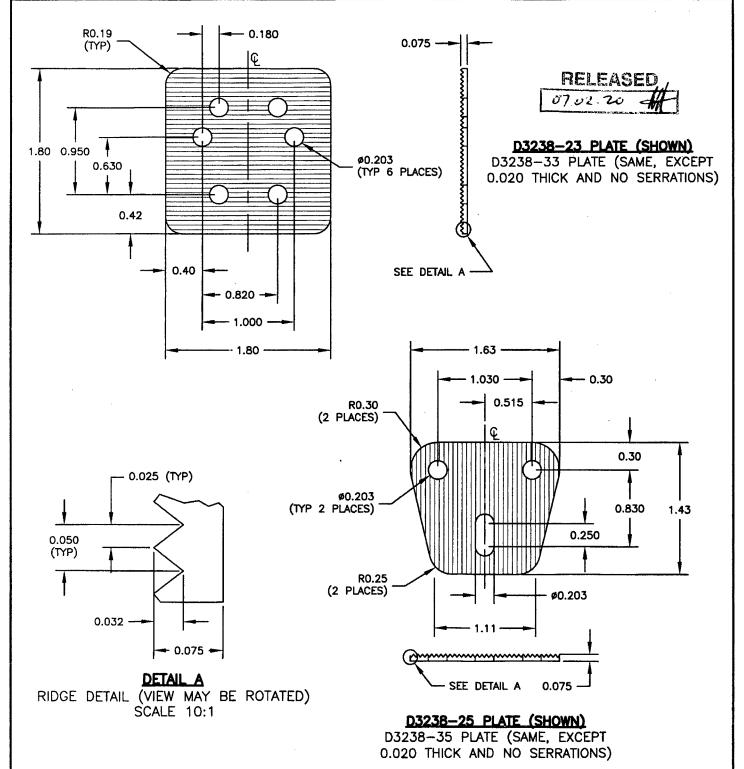


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